

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73417

Wednesday, August 31, 2011 3:09:18 PM



Item ID: D2731-3

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 8/31/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 rec'd



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage
attached C of C to W/O

130



QC

Quality Control

QC2- Inspect parts - second check

0.00

Memo

0.00

8/31/17

counts

830

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

80X J m 4/10/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 73417

Wednesday, August 31, 2011 3:09:18 PM



Page 3

Item ID:	D2731-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Mounting Lug					
Start Date:	8/31/2011	Start Qty:	80.00	Cust Item ID:		
Required Date:	9/16/2011	Req'd Qty:	80.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat								
	Powder Coating								
<div style="display: flex; justify-content: space-between;"> <div> <p><i>M117745</i></p> <p><i>3200f</i></p> </div> <div> <p>Memo</p> <p>START TIME: <i>2:40</i></p> <p>FINISH TIME: <i>3:10</i></p> <p>OVEN TEMPERATURE:</p> </div> </div>									

80X of M-11/10/20

160	QC3- Inspect Part Finish	0.00							
	QC								
	Quality Control								

80
counted *of M 11/10/20*

170	Identify as per dwg & Stock Location:	0.00							
	Packaging								
	Packaging								

40f
11/10/20 *800*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73417

Wednesday, August 31, 2011 3:09:18 PM



Page 4

Item ID: D2731-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 8/31/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 80.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/24

ME

11-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Wednesday, August 31, 2011 3:09:16 PM

Work Order ID: 73417



Parent Item: D2731-3



Parent Item Name: Mounting Lug

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: ☐D☐00.05.19☐Added inspect level 8, removed P/O for powder coating☐EC☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2731-3P 		Purchased	No			100	Each	0.0000	1	80			
Lug D2423 		Manufactured	No			110	f	538.5000	0.0683	5.751579			
Lug Extrusion													

Handwritten signature (80)

02/11/09/01 (80)

Location

Loc Qty

Loc Code

MAT006

538.5

43722

161.5

45800

1

68331

376

5.8

Dart Aerospace Ltd

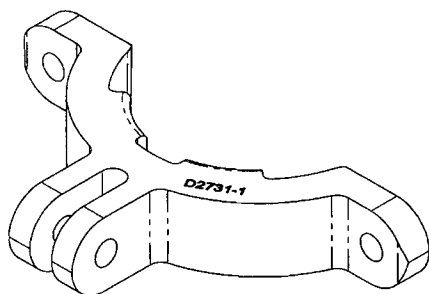
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

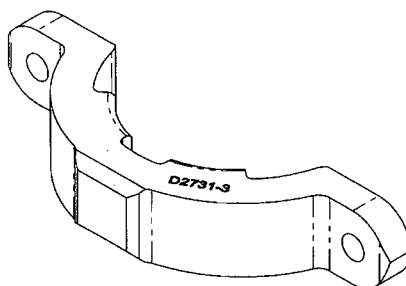
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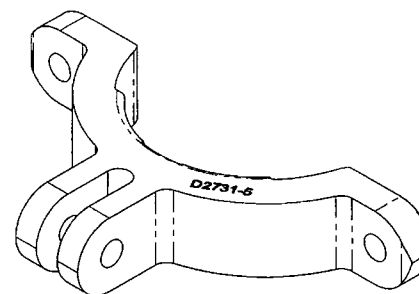
NOTE: Date & initial all entries



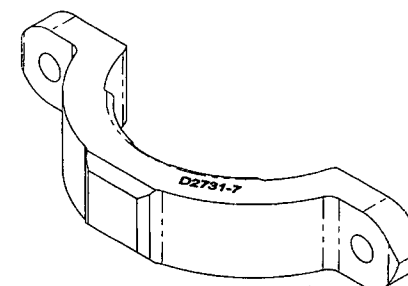
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

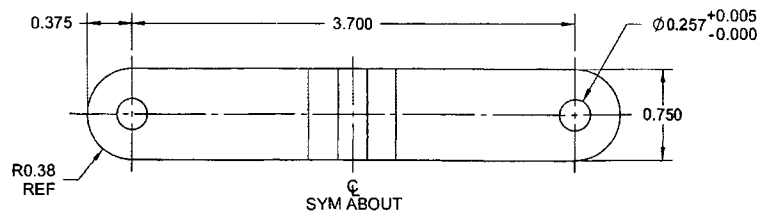
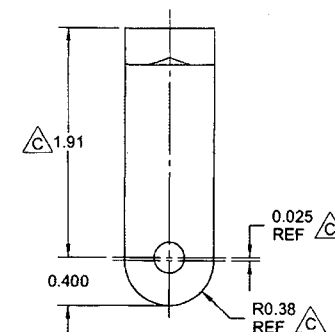
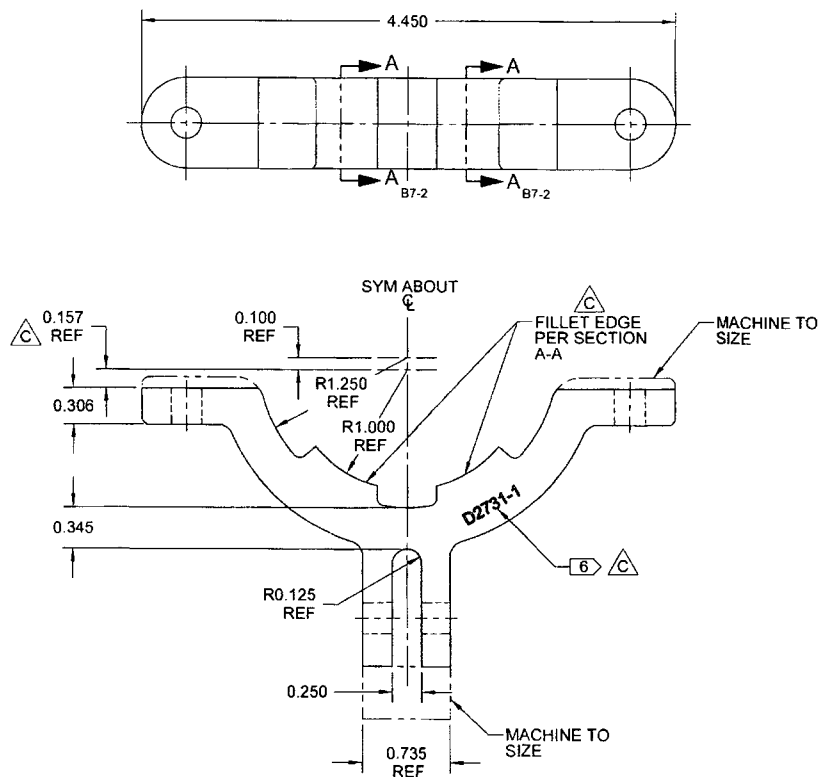
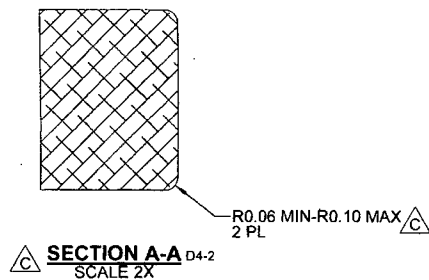
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73417
C.L. 10/9/01

**DEO ATTACHED
RELEASED**
09/02/19

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D2731-1 MOUNTING LUG

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09/06/25/41

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8

7

6

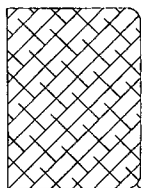
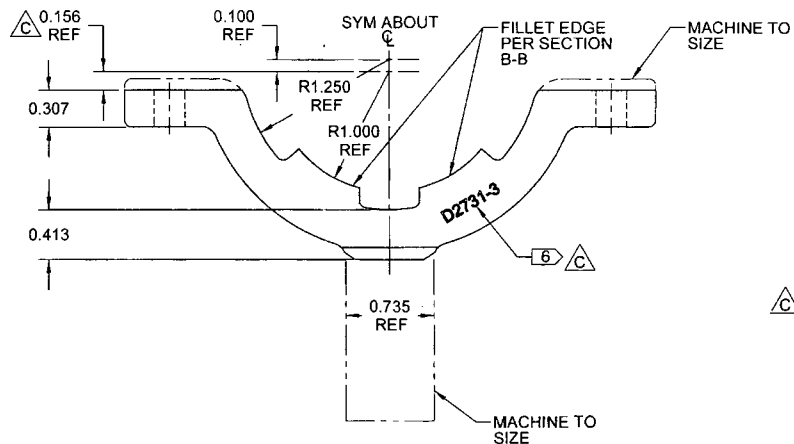
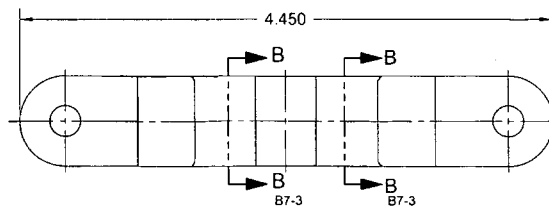
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4

3

2

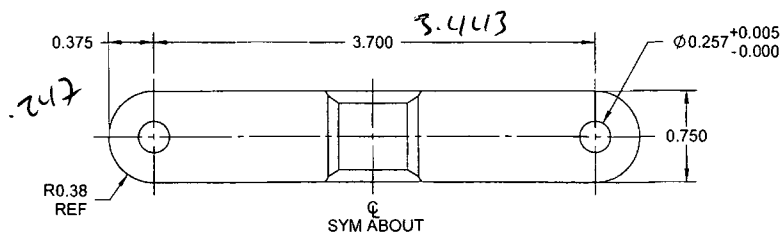
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R0.06 MIN-R0.10 MAX
2 PL

SECTION B-B D4-3
SCALE 2X

0.100 X 45° CMF
4 PL

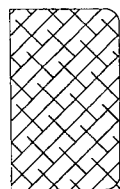


D2731-3 MOUNTING LUG

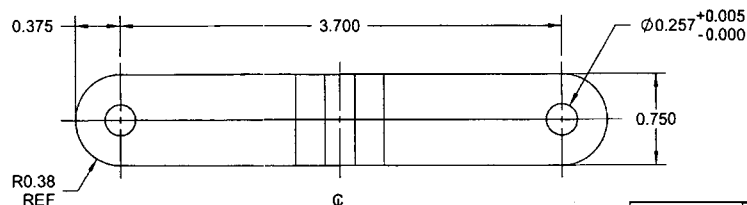
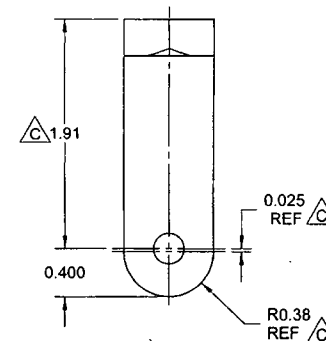
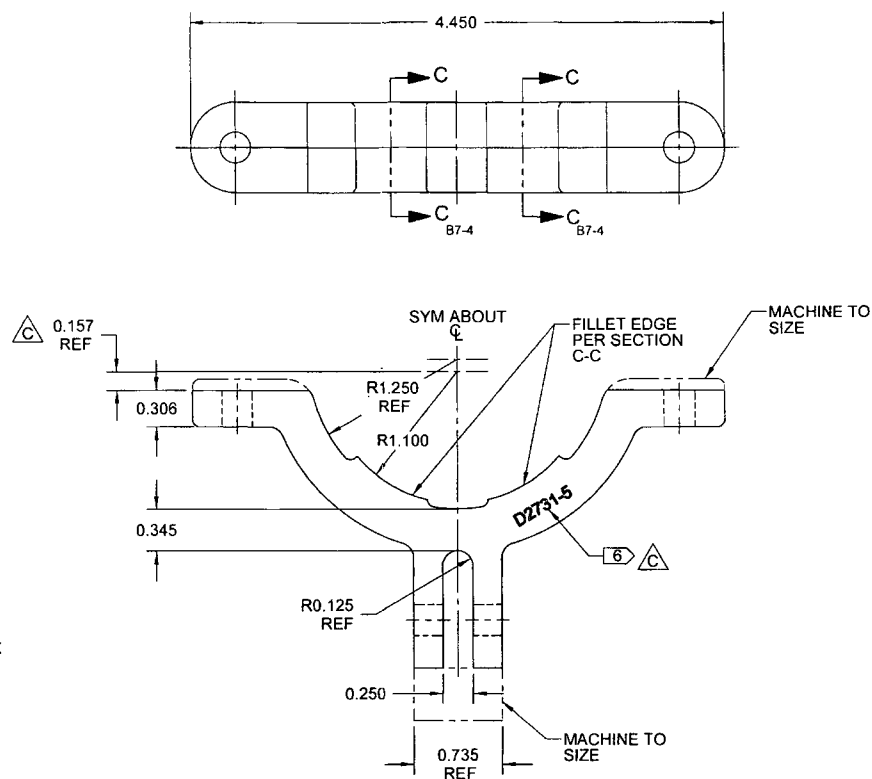
DEO ATTACHED
RELEASED
09/05/25

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MFG. APPR.		D2731	SHEET 3 OF 5
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SECTION C-C D4-4
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



D2731-5 MOUNTING LUG

**DEO ATTACHED
RELEASED**
9/14/25 JTB

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APPROVED		TITLE	SCALE
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8

7

6

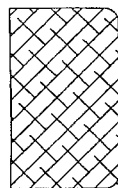
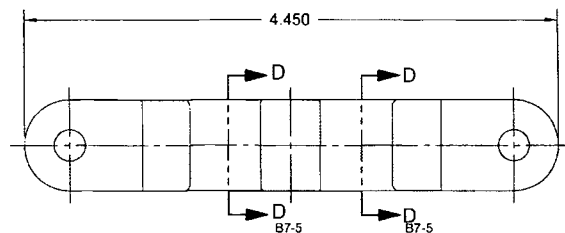
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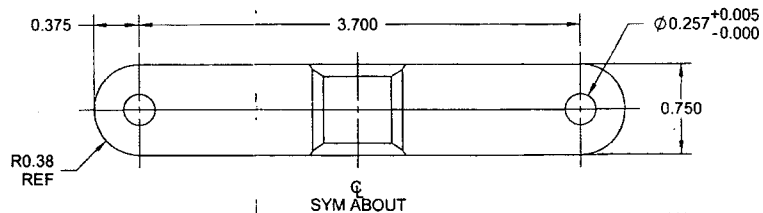
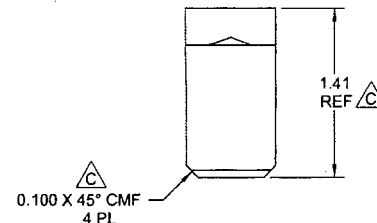
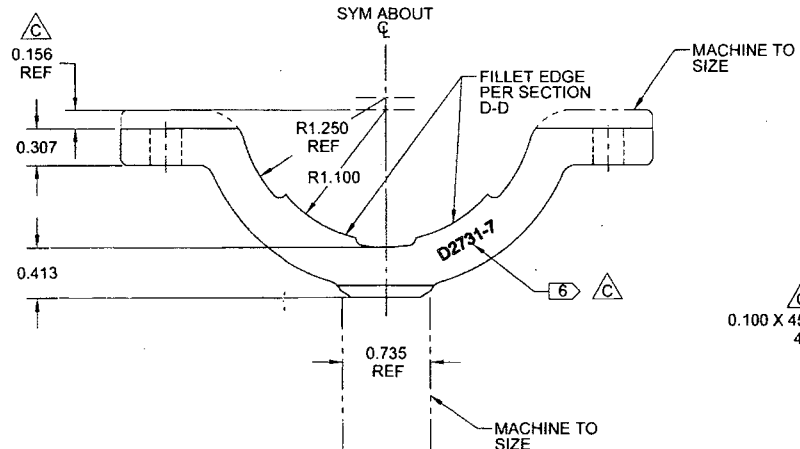
3

2

1



SECTION D-D D4-5
SCALE 2X
R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

DEO ATTACHED
RELEASED
109/66/25/47

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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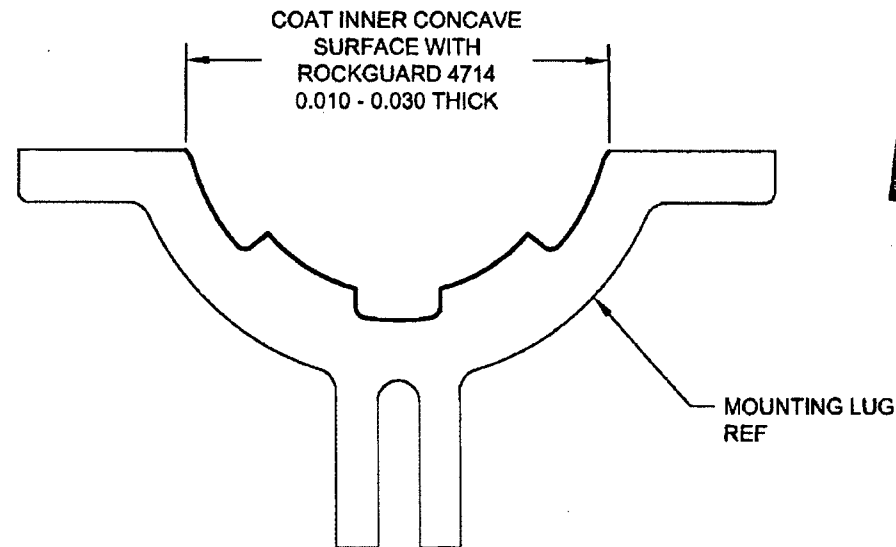
DRAWING NO. D2731	TITLE MOUNTING LUG	REV. C	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2731-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>sc</i>	MFG. APPR. <i>MA</i>	APPROVED <i>MA</i>		DE APPR. <i>MA</i>		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		

PURPOSE

ADD D2731-xRG OPTION

CHANGE

D2731-xRG MOUNTING LUGS ARE INDENTICAL TO D2731-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



RELEASED
2011-05-24
md

D2731-1RG MOUNTING LUG (SHOWN)
D2731-3RG/-5RG/-7RG MOUNTING LUGS (SIMILAR)




20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18232**
Date: Oct 13, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	
Order No.: 14799		Sold By: Dewar, Eric	
Shipped By: your truck		Ship Date: Oct 13, 2011	

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2731-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	80	80	
D2230-1 Mounting Lug Material supplied by DART: D2423 B68331	Each	100		
D2230-3 Mounting Lug Material supplied by DART: D2423 B68331	Each	200		
D3235-i Mounting Lug Material supplied by DART: D2423 B68331	Each	100		
D3394-1 Lug Assembly Material supplied by DART: D2423 B68331	Each	40		
D3910-1 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30		
3910-3 Crosstube Lug Material supplied by DART: D2423 B68331	Each	30		

The delivered goods must be inspected upon receipt to confirm compliance.
Should there be discrepancies please notify METEC within 30 days of delivery.
The goods are otherwise deemed accepted.

Received by 

Thank you for your order!

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
80	D2231-3	Mounting Lug	14799

MATERIAL: supplied by DART D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, Oct. 13, 2011